

Date: Monday, 9/11/2006 3:41:09 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 28469		
Estimate Number	: 11033		
P.O. Number	: N/A	Part Number	: D2803044
This Issue	: 9/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2803 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28159	Drawing Revision	: B
		Material	: N/A
Written By	:	Due Date	: 9/18/2006
Checked & Approved By	:	Qty:	5
Comment	: Est D 05.03.30 MS21043-3 was MS21042L3	Um:	8
		Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28032	STA 84 Bracket
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5



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s)

STA 84 BRACKET

Pick:

Qty	Part Number	Description
1	D2803-2	Bracket

Batch

B28444

B29404 x4  
 B28180 x1

ml07/03/14

2.0	D28054	Stop
-----	--------	------



5



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s)

STOP

Pick:

Qty	Part Number	Description
1	D2805-4	Stop

Batch

B28183

ml07/03/14

3.0	D2809	Bushing
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5



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s)

Bushing

Pick:

Qty	Part Number	Description
1	D2809	Bushing

Batch

B30749 x5

ml07/03/14 (x5)

Press D2805-4 into arm as per Dwg D2803

ml07/03/14 (x5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 9/11/2006 3:41:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28469

Part Number: D2803044

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC3

INSPECT PARTS AS THEY COME OFF MACHINE



20703-14 (5)



(PTO)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

POWDER COATING

POWDER COATING



m103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR/MR

07/03/14 (5)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m107/03/14 x5

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

m107/03/14 x5

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~16.0000~~ Each(s) 10

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M102760 x10

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~16.0000~~ Each(s) 10

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M19099 x10

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~32.0000~~ Each(s) 20

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M100993

A/R LPS-3 Corrosion Spray M101472

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

m107/03/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0703-14	4.0	QC 5 required, Remove QC 2. Penn change				<i>[Signature]</i> 0703-14	<i>[Signature]</i> 0703-14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:41:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28469

Part Number: D2803044

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2803.

ml 07/03/19 x5

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/19 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*[Signature]*

7/03/20 SD (5)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/20 (5)

Job Completion



11 07-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

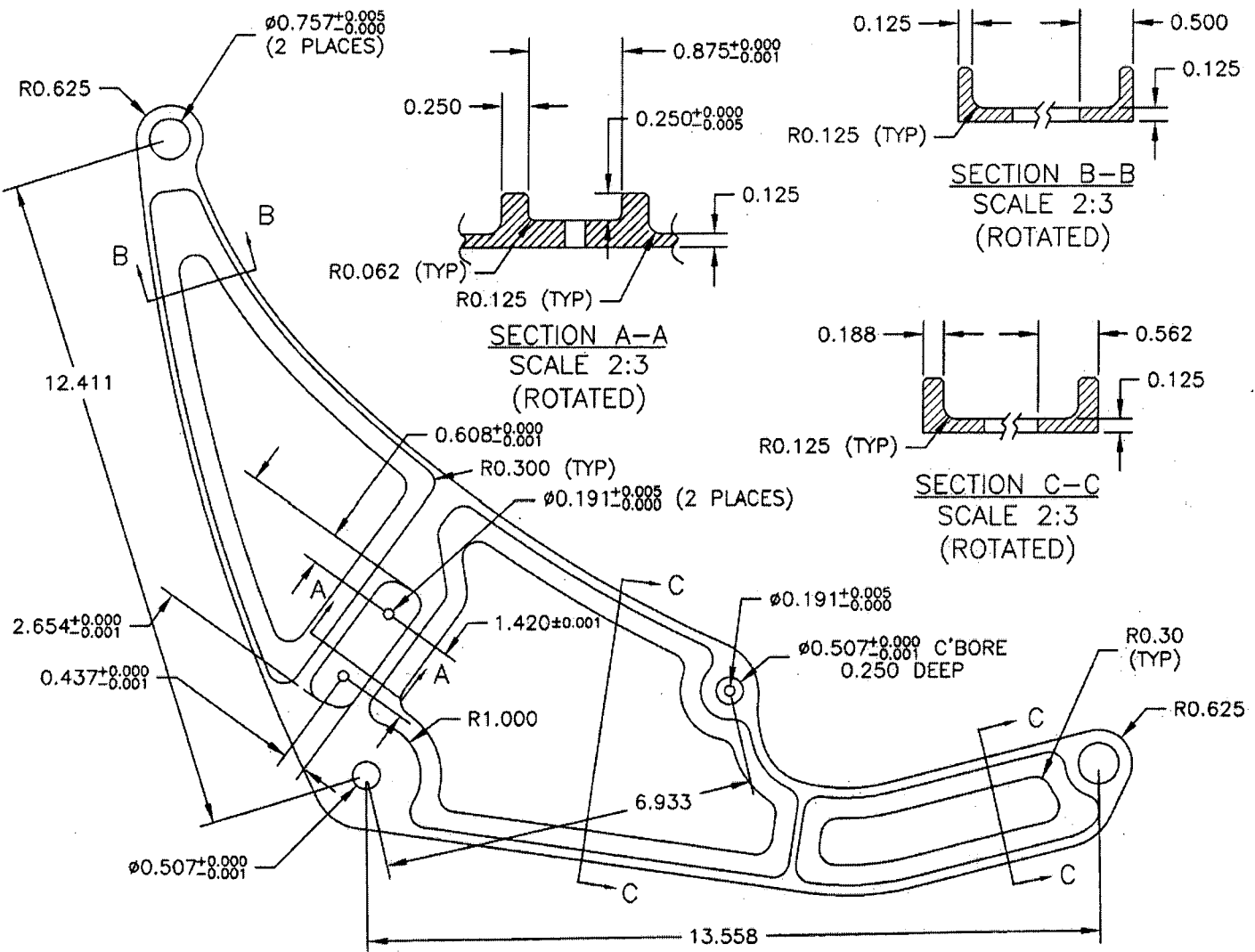
NOTE: Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

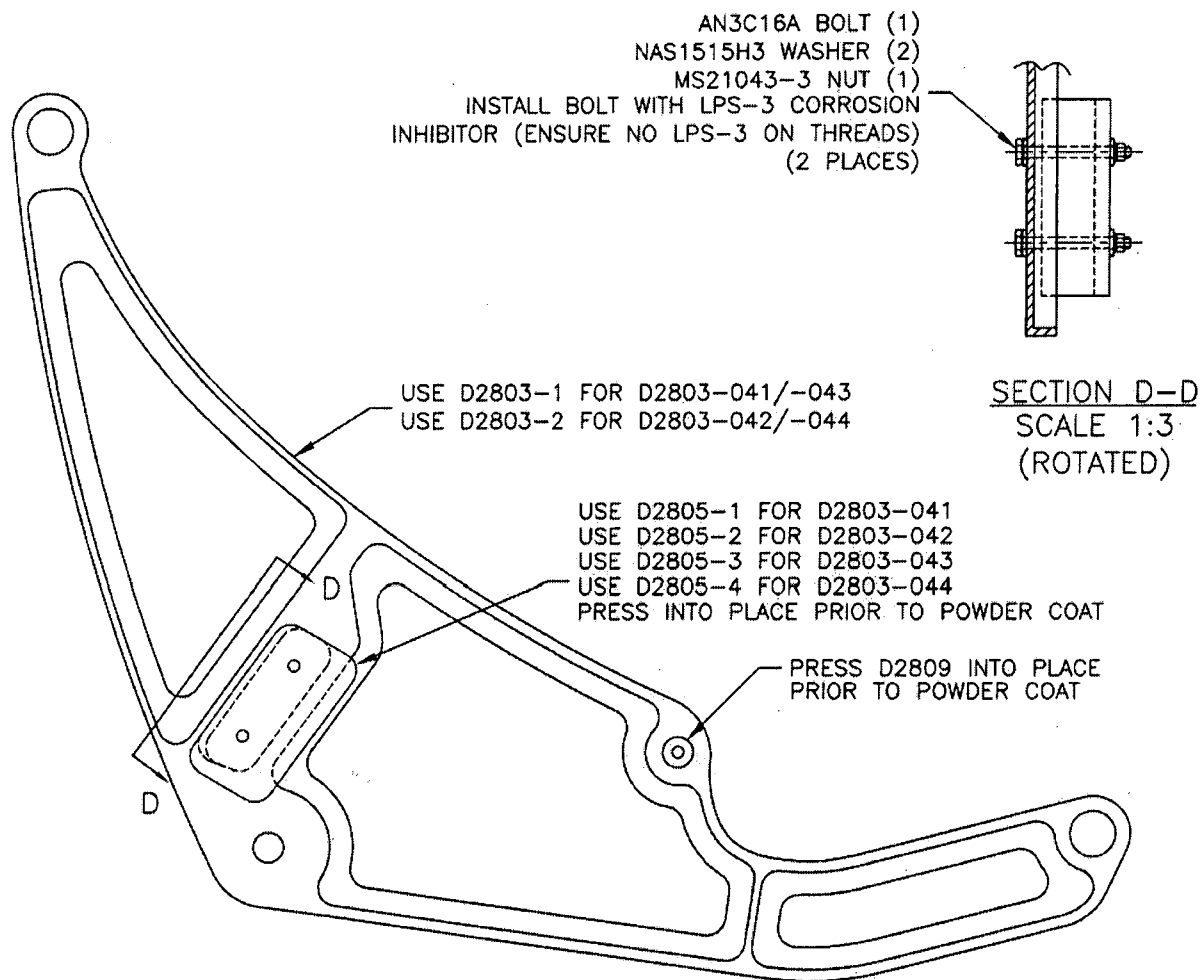
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



**D2803-041/-043 BRACKET ASS'Y (SHOWN),  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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